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JUL 13 2004

67056-002
P700600US-PCT/JG/SAC

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AMENDMENT

IN THE SPECIFICATION:

Please amend the paragraph on page 6, lines 24 to 34 as follows:

The constricting orifice 30 of the plasma torch 12 projects from the carriage 14 and is shrouded by a clamp cup 32 carried by the carriage 14. The clamp cup 32 is connected to the carriage 14 by a retaining ring 78. The clamp cup 32 serves, in use, both to clamp a work piece 34 and to ensure adequate gas shielding of the weld site. Both functions of the clamp cup 32 will be described in more detail below. The carriage 14 is provided with cooling channels 36 to allow the circulation of coolant to cool the plasma torch 12 when it is in operation. The plasma torch 12 is retained in the carriage 14 by a tubular retaining sheath 38. The sheath 38 also houses the gas and power connections 40,42 of the plasma torch 12